Tuesday, 9/25/2007 10:09:37 AM Date: User: Kim Johnston Process Sheet : PILOT/CO-PILOT STEP, RH (FOLDING) **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 34836 Estimate Number : 10824 : D412630032 Part Number P.O. Number : NIA 07.09.25 DC · IIN LUREY P19 S.O. No. : NA This Issue : 9/25/2007 Drawing Number : N/A Project Number Prsht Rev. MA : LARGE FAB ASSY ; K Type **Drawing Revision** First Issue : NIA : 33696 Material Previous Run Each : 10/9/2007 Due Date Written By Checked & Approved By **NEW ISSUE** EC : EST. REV. 05.11.21 Comment updated pick list EC EST. REV. B 05.12.19 Additional Product Job Number: Machine Or Operation: Description: Seq. #: DOCUMENT CONTROL 1.0 Comment: DOCUMENT CONTROL Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.17 07-10-16 ****ensure tension to retract step is 11 to 18 lbs before installing lockwire.**** Step Weldment 3.0 D3463042 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Part Number Description Qty Step weldment D3463-042 1 D3443043 Strut Weldment Assembly 4.0 Comment: Qty.: 1.0000 Each(s)/Unit 4.0000 Each(s) Total: Pick: Part Number Description Qty 1 D3443-043 Strut ass'y D3443041 50 Comment: Qty.: 1.0000 Each(s)/Unit 4.0000 Each(s) Total: Pick: Qty Part Number Description D3443-041 Strut ass'y

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Tuesday, 9/25/2007 10:09:37 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 34836 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: COTTER PIN MS24665227 11.0 Comment: Qty.: Total: 4.0000 Each(s) 1.0000 Each(s)/Unit Pick: Part Number Description Qty MS24665-227 COTTER PIN 1 D34551 Spacer 12.0 Comment: Qty.: 8.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Description Qty Part Number Batch 2 D3455-1 Spacer D34651 13.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Description Qty Part Number D3465-1 Washer 1 AN3107 14.0 Comment: Qty.: 4.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Description Qty Part Number 103286 AN310-7 1 Nut 15.0 MS24665302 Cotter Pin Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description MS24665-302 COTTER PIN 1

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Date: Tuesday, 9/25/2007 10:09:37 AM User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 34836 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 160 QC5 Comment: INSPECT WORK TO CURRENT STEP ****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab. PACKAGING 1 17.0 Comment: PACKAGING RESOURCE #1 Pick Packing Kit Bushing D34541 18.0 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Description Qty Part Number B33730. Bushing 1 D3454-1 D34543 Bushing 19.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: Qty Part Number Description Bushing 2 D3454-3 D34545 20.0 Comment: Qty.: Total: 8.0000 Each(s) 2.0000 Each(s)/Unit Pick: Part Number Description Qty 2 D3454-5 Bushing 21.0 D34551 Spacer Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s) Pick: Batch R 2817/ Description Part Number Qty 6 D3455-1 Spacer

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Date: Tuesday, 9/25/2007 10:09:37 AM Kim Johnston User: **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 34836 Part Number: D412630032 Job Number: Description: Seq. #: Machine Or Operation: Spacer 22.0 D34553 8.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: Qty Part Number Description 2 D3455-3 Spacer D3462042 Bracket Assembly 23.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description Batch 34843-D3462-042 Bracket ass'y 1 AN3104 24.0 Comment: Qty.: Total: 4.0000 Each(s) 1.0000 Each(s)/Unit Pick: Description Qty Part Number M105280-1 AN310-4 Nut AN3105 25 0 8.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: Qty Part Number Description 1105211-2 AN310-5 Nut 26.0 AN3C5A Comment: Qty.: Total: 3.0000 Each(s)/Unit 12.0000 Each(s) Pick: Batch 1105426 Qty Part Number Description AN3-C5A Bolt 3 27.0 AN44C12 eyebolt Comment: Qty.: 4.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Batch Qty Part Number Description Page 5

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Tuesday, 9/25/2007 10:09:37 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 34836 Job Number: Description: Seq. #: Machine Or Operation: Eyebolt 1 AN44-C12 BOLT AN4C15 28.0 4.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: Qty Part Number Description AN4C15 BOLT 1 29.0 AN5C11 BOLT Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: M103248_ Description Qty Part Number BOLT AN5C11 1 30.0 AN5C15 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description 1105160-AN5C15 BOLT 1 31.0 AN960C10 WASHER Comment: Qty.: 7.0000 EACH(s)/Unit Total: 28.0000 EACH(s) Pick: Qty Part Number Description 4101064-AN960C10 Washer 32.0 AN960C516 WASHER Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Batch 17697 Qty Part Number Description AN960C516 Washer 1

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Tuesday, 9/25/2007 10:09:37 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630032 Job Number: 34836 Job Number: Seq. #: Description: Machine Or Operation: 33.0 MS210433 12.0000 Each(s) Comment: Qtv.: 3.0000 Each(s)/Unit Total: Pick: Part Number Description Qtv MS21043-3 Nut 3 MS24665227 COTTER PIN 34.0 Comment: Qty.: 8.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Description Qty Part Number **COTTER PIN** MS24665-227 2 COTTER PIN MS24665229 35.0 Comment: Qty.: Total: 8.0000 Each(s) 2.0000 Each(s)/Unit Pick: Description Part Number Qty 2 MS24665-229 **COTTER PIN** 36.0 NAS1515H5 Comment: Qty.: Total: 4.0000 Each(s) 1.0000 Each(s)/Unit Pick: Description Qty Part Number Washer NAS1515H5 1 INSPECT 100% KITS FOR COMPLETENESS 370 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 38.0 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-031 Location:_ PPP Rev:

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

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Part Number: D412630032

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Comment: FINAL INSPECTION/W/O RELEASE

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FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

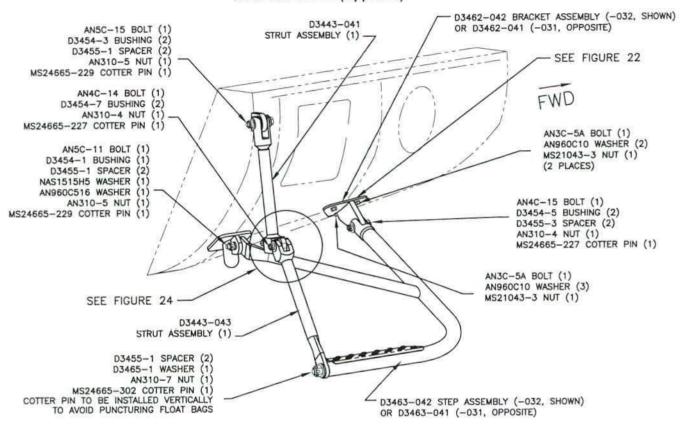
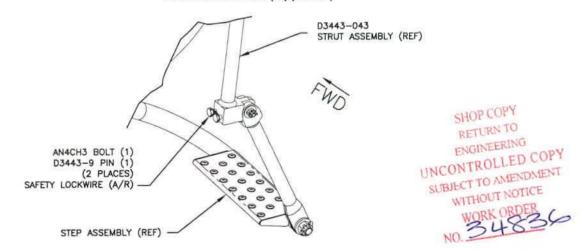


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH,Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)



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Revision:

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Date: 06.10.05